

# Work Order ID 84271

\*84271\*

Page 1

May-08-12 3:57:56 PM

Item ID: D4544-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Center

Start Date: 08/05/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MCO

Date: 12/05/08 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4544	A B M								
100	Manufacture as per dwg	0.00							
*100*									
Mill Conv	Memo	0.00							
Conventional Milling Machine	mill as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
115		0.00							
*115*									
Small Fab	Memo	0.00							
Small Fab	FORM AS PER DWG								

12-05-16

12-5-23

12/05/08

12 07 09

12

2

12/05/08

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	QC Inspector

Part No: D4544-1 PAR #: \_\_\_\_\_ Fault Category: Nonconformity Feedback NCR: Yes No DQA: Not Date: 12/01/10  
Resolution: CRAP Disposition: CRAP QA: N/C Closed: ✓ Date: 12/7/10

NCR: <u>12-1579</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>559.30 + 2 = \$ 504.60</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/01/10</u>	<u>11"</u>	<u>124T COULD NOT BE BENT WITHOUT CRACKING IN RADIOS.</u>		<u>SOURCE VENDOR TO MANUFACTURE EXTRUSION.</u>	<u>✓</u> <u>12/07/10</u>	<u>SM</u>		<u>SM</u>

NOTE: Date & initial all entries

# Work Order ID 84271

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**\*84271\***

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Setup Start **\*NS1\***

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Start Date: 08/05/2012 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

• QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

117

QC5- Inspect part completeness to step on W/O

0.00

**\*117\***

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

130

QC7-Inspect Chemical Conversion Coat

0.00

**\*130\***

QC

Memo

0.00

Quality Control

**Work Order ID 84271**

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**\*84271\***

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Item ID: D4544-1

Revision ID:

Item Name: Retainer, Center

Start Date: 08/05/2012 Start Qty: 2.00

Required Date: 22/05/2012 Req'd Qty: 2.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

May-08-12 3:58:00 PM

Work Order ID: 84271

\*84271\*

Parent Item: D4544-1

\*D4544-1\*

Parent Item Name: Retainer, Center

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.17 new issue EC verified by:DD  
 REV:B 12.02.24 as per dwg reva DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.00 0		Purchased		No		100	f	34.2100	3.95	8.315789			

\*M6061T6B0 250X02 000\*

\*\*

6061-T6 Bar .250 X 2.00

.25" x 2.50"

Location

MAT001

107436

Loc Qty

34.21

34.21

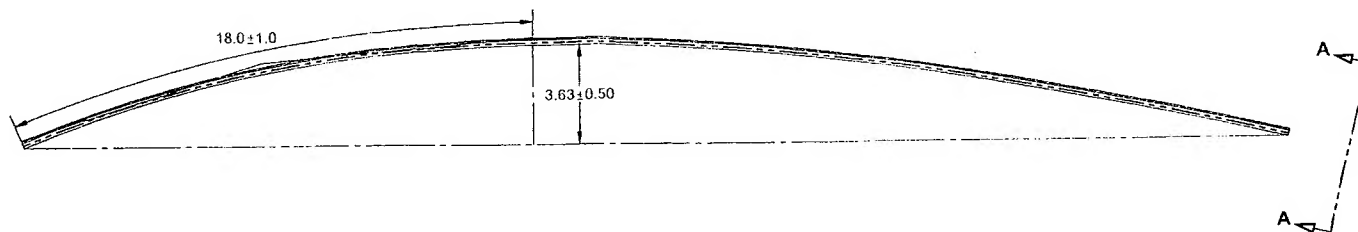
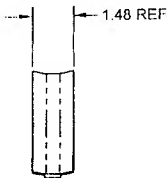
Loc Code

8.4 70 12-05-16

Jed

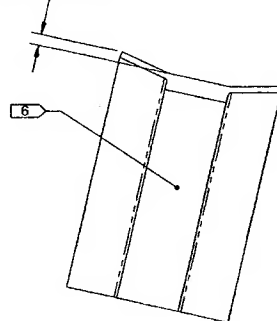
12-05-23

This Batch only.



**D4544-1 RETAINER, CENTER**

FORM TO 0.10 TYP  
(D4544-1F ONLY)



**VIEW A-A**  
SCALE 4X  
CROPPED VIEW

84271 MLJ  
12/05/08

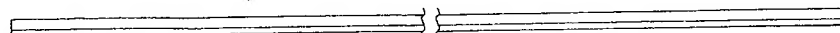
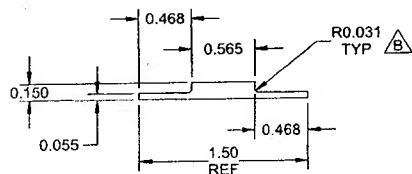
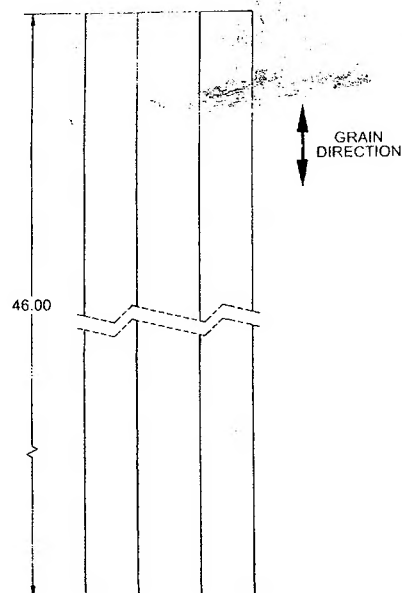
RELEASED  
2012-05-08

**NOTES:**

- 1) MATERIAL: MAKE FROM D4544-1F OR D4544-3-460  
FLAT LENGTH = 46.00"
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4544-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.61 lbs

B	ADD -1F (WAS -1); ADD -3; -1 NOW BENT AND FORMED, R0.031 WAS R0.015 (88-2)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	g	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	g		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4544	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, CENTER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

14271



**D4544-1F RETAINER, CENTER**

RELEASED  
2012-05-07

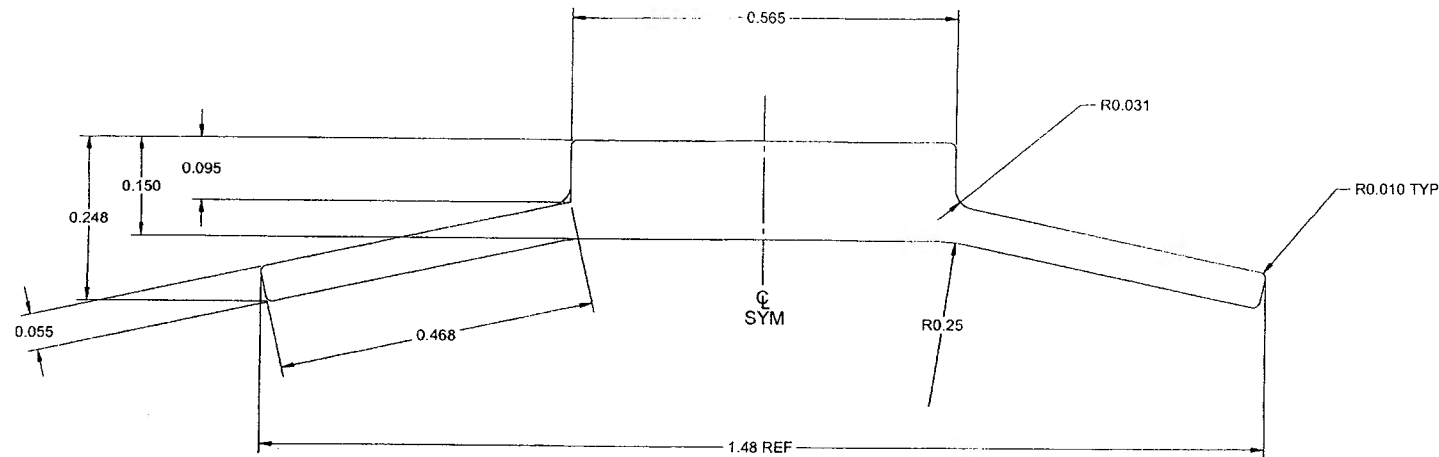
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET OR BAR  
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR QQ-A-250/11 OR AMS-QQ-A-250/11 (OR AMS 4025/4027)  
 OR ASTM B211 OR ASTM B221 OR ASTM B209  
 REF DART SPEC. M6061T6S OR M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. <b>D4544</b>	REV. B
MFG. APPR.	AS		SHEET 2 OF 3
APPROVED	AS	TITLE <b>RETAINER, CENTER</b>	SCALE NTS
DE APPR.	AS	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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# SPECIFICATION CONTROL DRAWING

04271



**D4544-3-XXX EXTRUSION**

2012-05-07  
2012-05-07

## NOTES:

1) D4544-3-XXX EXTRUSION

LENGTH

WHERE 'XXX' IS LENGTH IN TENTHS OF AN INCH  
EG. 46" LONG EXTRUSION = D4544-3-460

- 2) MATERIAL: 6061-T6 ALUMINUM EXTRUSION PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.0137 lb/in
- 8) NO TOOLING ID MARKS

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4544	REV. B
MFG. APPR.			SHEET 3 OF 3
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